

Work Order ID 123011

123011

Page 1

Tuesday, July 29, 2014 2:28:19 PM

Item ID: D4324-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm Support Assembly
 Start Date: 7/29/14 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 7/29/14 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: J. A Date: 14/07/30 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4324	B

100 Weld per dwg A/R S.S. rod Batch: M123013 0.00
 100
 Large Fab Memo 0.00
 Large Fab

x5 15-04-30 MAL

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 110
 QC Memo 0.00
 Quality Control

5 15-5-5 DAS 50 9-89

120 QC5- Inspect part completeness to step on W/O 0.00
 120
 QC Memo 0.00
 Quality Control

5 15-5-5 DAS 50 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 123011

Tuesday, July 29, 2014 2:28:19 PM

123011

Page 2

Item ID: D4324-043 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Arm Support Assembly Stop *NS2*

Start Date: 7/29/14 Start Qty: 4.00 *4*

Required Date: 7/29/14 Req'd Qty: 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>st 100</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

S
08-6
LZ
840
MAY 05 2015

MLJ MAY 05 2015

MLJ MAY 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Tuesday, July 29, 2014 2:28:18 PM

Page 1

Work Order ID: 123011

123011

Parent Item: D4324-043

D4324-043

Parent Item Name: Arm Support Assembly

Start Date: 7/29/14

Required Date: 7/29/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.04.04 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C3		Purchased	No			100	Each	45.0000	1	4			

AN310C3

NUT

Location	Loc Qty	Loc Code
ST331	45	
114714	1	
M128429	20	
M128818	24	

x 5

x5

15-04-29 MAL

D4324-3

Manufactured No

D4324-3

Support Plate

Location	Loc Qty	Loc Code
WA002	5	
116633	5	

x 5

x5

15-04-29 MAL

D4324-7

Manufactured No

D4324-7

Tube

Location	Loc Qty	Loc Code
ST103	10	
116635	10	

x 5

x5

15-04-29 MAL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

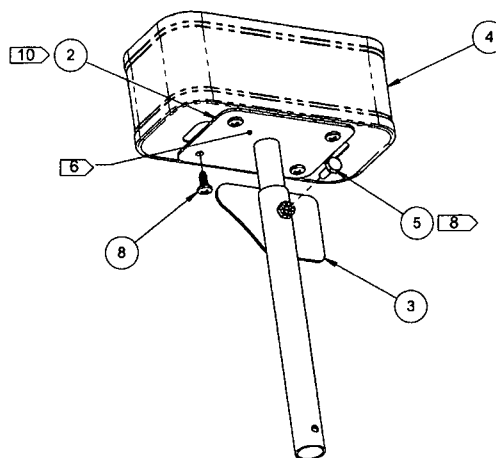
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM	QTY -011	P/N	DESCRIPTION
1	X	D4324-011	ARM REST ASSEMBLY
2	1	D4324-041	ARM REST WELDMENT
3	1	D4324-043	ARM SUPPORT ASSEMBLY
4	1	D4324-045	CUSHION ASSEMBLY
5	3	AN3-4A	BOLT
6	1	AN3-12A	BOLT
7	3	MS21075L3	NUT PLATE
8	4	MS51861-45C	SCREW
9	3	NAS1149F0332P	WASHER
10	1	NAS1149F0363P	WASHER



D4324-011 ARM REST ASSEMBLY
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-18) 

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.83 lbs
- 8) INSTALL HARDWARE HAND TIGHT ONLY
- 9) BAG LOOSE HARDWARE
- 10) CENTER D4324-041 ON D4324-045 AS SHOWN

J.A

14/07/30

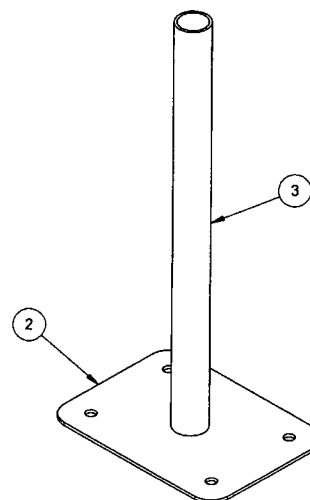
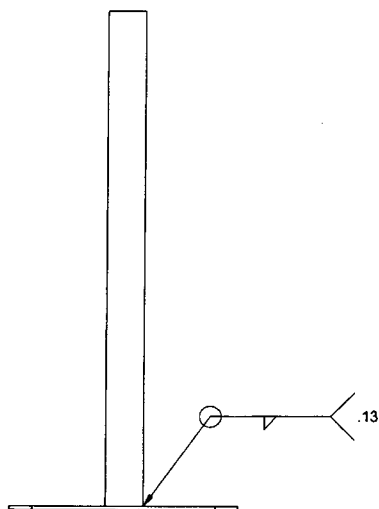
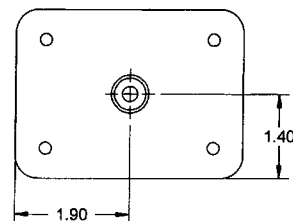
123011

RELEASED
2014-04-23

B	ADD D4324-011 (ZN B4-1) & D4324-045 (ZN B4-4); REVISE D4324-041 NAME (ZN B4-2, D4-2); ADD Ø0.204 HOLES (ZN D5-5) & Ø0.25 HOLE (ZN D4-5); 8.30 WAS 8.95 (ZN C5-7); REVISE IDENTIFICATION NOTES; REF PAR13-319	RF	14.04.03
A	NEW ISSUE	RF	11.01.31
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
DATE	14.04.03	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4324-041	ARM REST WELDMENT
2	1	D4324-1	BASE PLATE
3	1	D4324-5	TUBE



D4324-041 ARM REST WELDMENT
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) B

NOTES:

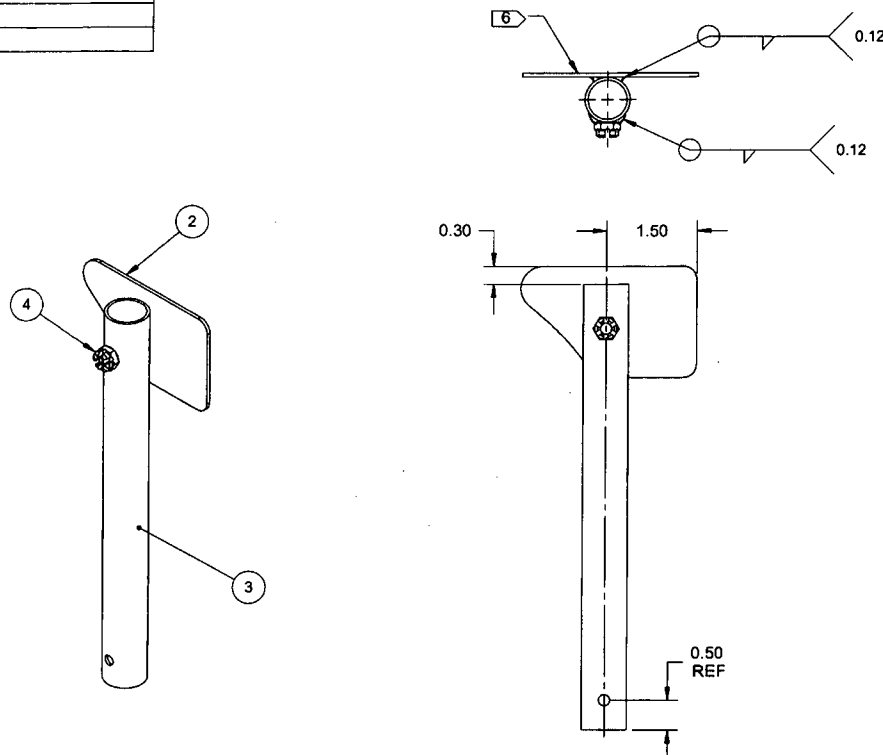
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs
- 8) WELD PER DART QSI 004

RELEASED
2014-04-23

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4324-043	ARM SUPPORT ASSEMBLY
2	1	D4324-3	SUPPORT PLATE
3	1	D4324-7	TUBE
4	1	AN310C3	NUT, CASTELLATED



D4324-043 ARM SUPPORT ASSEMBLY
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) 

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.32 lbs
- 8) WELD PER DART QSI 004

APPROVED

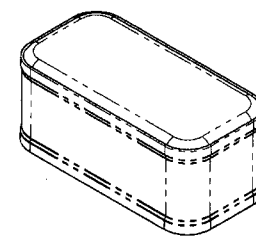
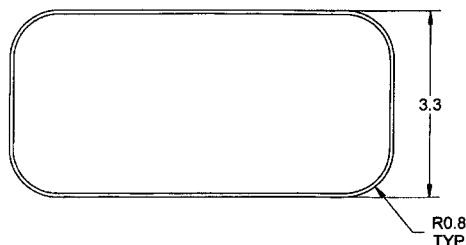
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DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 3 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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2014-04-23
WJP

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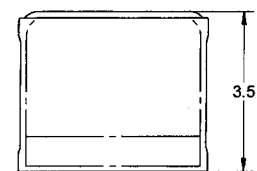
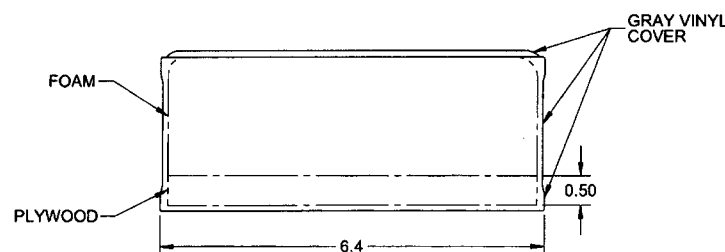
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D



C

C



B

B

D4324-045 CUSHION ASSEMBLY
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16)

RELEASED
2014-04-23
WD

A

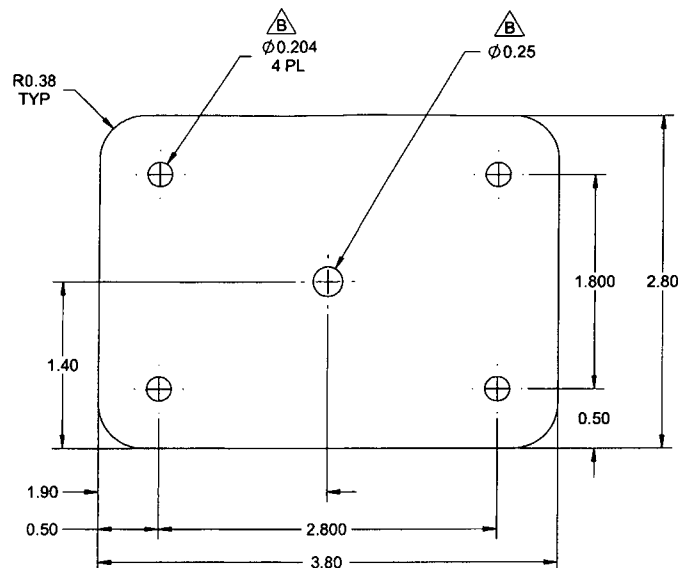
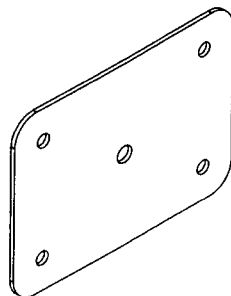
A

- NOTES:**
1) MATERIAL: AS SHOWN
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 4 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D4324-1 BASE PLATE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) $\triangle B$

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

RELEASED
2014-04-23

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	DC	DRAWING NO.	REV. B
	MFG. APPR.	DD	D4324	SHEET 5 OF 7
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	ARM REST ASSEMBLY	NTS
DATE 14.04.03			COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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D

C

B

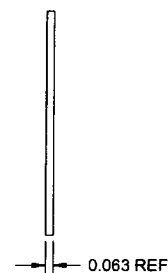
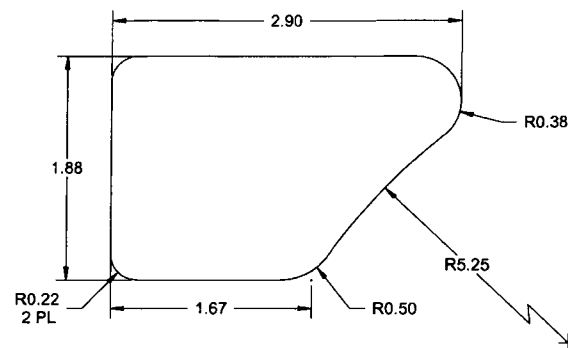
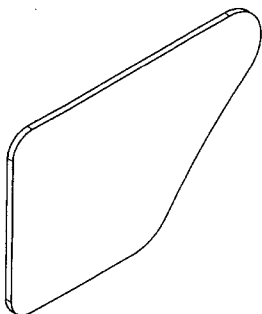
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D

C

B

A



D4324-3 SUPPORT PLATE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) $\triangle$ B

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.063 (16 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

RELEASED
2014-04-23
WP

RELEASED
2014-04-23

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 6 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
DATE	14.04.03	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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7

6

5

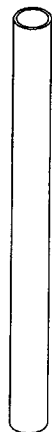
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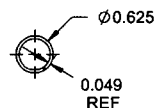
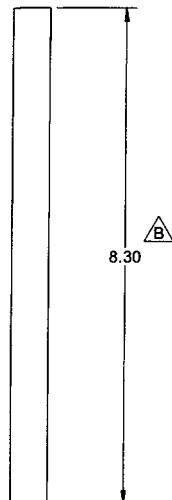
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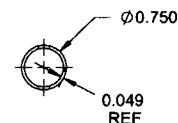
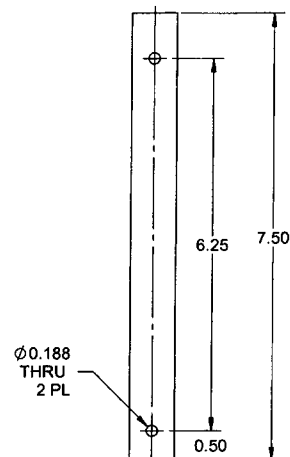
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D4324-5 TUBE



D4324-5 TUBE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) **B**



D4324-7 TUBE
(REF. EAGLE DRAWING No. D2046902, PART OF P/N EA20469-16) **B**



D4324-7 TUBE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF DART SPEC. M304TR0.625W.049 & M304TR0.75W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4324-5 = 0.21 lbs
D4324-7 = 0.23 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DD	D4324	SHEET 7 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	ARM REST ASSEMBLY	NTS
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